

Serial No.: 10/611,842

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Amendment Date: 5/30/2007

II. AMENDMENTS TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in this Application:

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1. through 8. (canceled)

9. (previously presented) A draw die for tube bending, the die having a bending surface configuration comprising:

a curve extending between first and second ends;

a portion of the curve being a circular arc; and

a clothoid transition portion extending from the second end toward the circular arc having a radius of curvature decreasing from zero curvature to a radius of curvature of the circular arc at a point of integration; and,

including a second transition portion extending from the arc portion toward the first end having a curvature decreasing from the bending radius of the arc to the zero curvature.

10. (previously presented) The draw die of claim 9 wherein the curve subtends an angle of 90 degrees.

11. (previously presented) The draw die of claim 9 wherein the curve subtends an angle greater than 90 degrees.

12. (previously presented) The draw die of claim 9 wherein the curve subtends an angle less than 90 degrees.

13. (canceled)

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14. (previously presented) The draw die of claim 9, wherein the shape and arc length of the transition portion is defined by a length and an angle of the portion of the curve being the circular arc.